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D2353
Job Sheet 184639



Part No: D2353

Job Qty: 10 ea

Part Name: Stiffener



Part Weight: 0 lbs

Job Created: 10/15/18

Due Date: 10/19/18

Type: SOLD

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG REV C IPP Rev: A Removed from 9 Digit 05-11-10 EC IPP: B 06.11.15 waterjet EC IPP: c 06.12.07 ecn 836 ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	10 pcs	10/19/18	10/19/18	0.00	0.62	Waterjet 1		38 10/10/18
120	QC	10 pcs	10/19/18	10/19/18	0.00	0.00	QC8		38
130	Brake NC	10 pcs	10/19/18	10/19/18	0.02	0.38	Brake NC 1		38
140	QC	10 pcs	10/19/18	10/19/18	0.00	0.00	QC5		38
150	HandFinish	10 pcs	10/19/18	10/19/18	0.00	0.42	HandFinish1		38
155	QC	10 pcs	10/19/18	10/19/18	0.00	0.00	QC7		38
160	Powdercoat	10 pcs	10/19/18	10/19/18	0.00	0.15	Powdercoat4		38
170	QC	10 pcs	10/19/18	10/19/18	0.00	0.00	QC3		38
180	Packaging	10 pcs	10/19/18	10/19/18	0.00	0.00	Packaging3		38
190	QC21-SA	10 Ea	10/19/18	10/19/18	0.00	0.00	QC21		38

Part Op 100 - 1-Cut as per Dwg D2353

Descriptions: 130 - Bend per Dwg D2353

160 - START TIME: 10:05

TEMP: 320° FINISH: 10:35

M137839

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	1.4630 sf (.1463 ea)	100-Waterjet	M137626

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M2024T3S.050	1	46	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Stiffener	15.198Inches ± 0.010	15.208 15.188	15,200	
2	Stiffener	0.966Inches ± 0.005	0.971 0.961	0,970	
3	Stiffener	0.354Inches ± 0.010	0.364 0.344	0,352	
4	Stiffener	0.128Inches	0.133	0,128	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
NCR No. _____		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

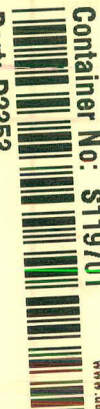
Date : _____ Step #: _____ QTV Effective: _____

Description Work Order Deviation

		42) Approval
		ated By
		Supervisor erification
		ordinator val

Part: D2353
 Job No: 184639
 Serial No/Batch: S119701
 Revision:
 Inspector:
 Exp Date:
 Instructions: Various STC's

Date: 10/18/18



DART
 AEROSPACE
 Container No: S119701
 1270 Aberdeen Street
 Markham, ON L3R 9V7
 CANADA
 TEL: 1 813 832-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Root Cause			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Wrong
Design ☐	Operator ☐	Bending ☐	tensions
Doc/Data ☐	Offset/Setup ☐	Centre Not Conc ☐	tolerance
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Part Incorrect
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple, wave ☐	Part Lost/Missing
Material ☐	Use for Testing ☐	Cuffs ☐	Part Moved
Internal Transport ☐	Poor Information ☐	Crushing ☐	Drawing
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Finish
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Misread
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Turning Sequence
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	

+ 0.005
- 0.000

0.128

Plex 10/15/18 1:42 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					